

Date: Friday, 9/14/2007 2:01:19 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ACCESS PANEL ASSEMBLY
Job Number : 34674	
Estimate Number : 12949	
P.O. Number : <i>N/A</i>	Part Number : D3259042
This Issue : 9/14/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3249 REV A1
Prsht Rev. : <i>NC</i>	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : 34241	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 9/30/2007 Qty: 4 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A New Issue 07-07-19 JLM Verified By:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Pick Assembly Kit

2.0	D32591	panel
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 panel  
 Batch: *1334250* *SP* *34734*

3.0	D32594	Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Doubler  
 Batch: *34252* *SP*

4.0	D32595	Spacer
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Spacer  
 Batch: *34253* *34737* *SP*

5.0	D32597	Door
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Door  
 Batch: *1334254* *plu/loc* *SP*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 9/14/2007 2:01:19 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 34674

Part Number: D3259042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D31615

Hinge 9.9"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Hinge 9.9"

Batch: 33671

SC

7.0

D32601

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Spring

Batch: 33678

1334255

SC

8.0

127H5

HALF GROMMET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

HALF GROMMET

Batch: 15058

3  
1105518

SC

9.0

250018C3Y

RIGHT RECEPTACLE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

RIGHT RECEPTACLE

Batch: 115131

100034

SC

10.0

2501W20020C3Y

STUD



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

STUD

Batch: 115131

1100398

SC

11.0

MS20426AD44

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Rivet

Batch: 11001

SC

PTO

12.0

MS20470AD34

Rivet, Universal Head



Comment: Qty.: 36.0000 Each(s)/Unit Total : 144.0000 Each(s)

Rivet, Universal Head

Batch: 115541

7/11/06 SC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/10/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/14/2007 2:01:19 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 34674

Part Number: D3259042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS20470AD35

Rivet



Comment: Qty.: 10.0000 Each(s)/Unit Total : 40.0000 Each(s)

Rivet

Batch:

9682 7/11/08 50 yr

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3259-041 as per Dwg D3259 .

Note: Keep .040" Gap all around door.

ml 07/11/08

(x4)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



8 & 07/11/08 (x8)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location:

5224

AS

07/11/09

Handwritten signature

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/09

Job Completion



Handwritten signature and date 07/11/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

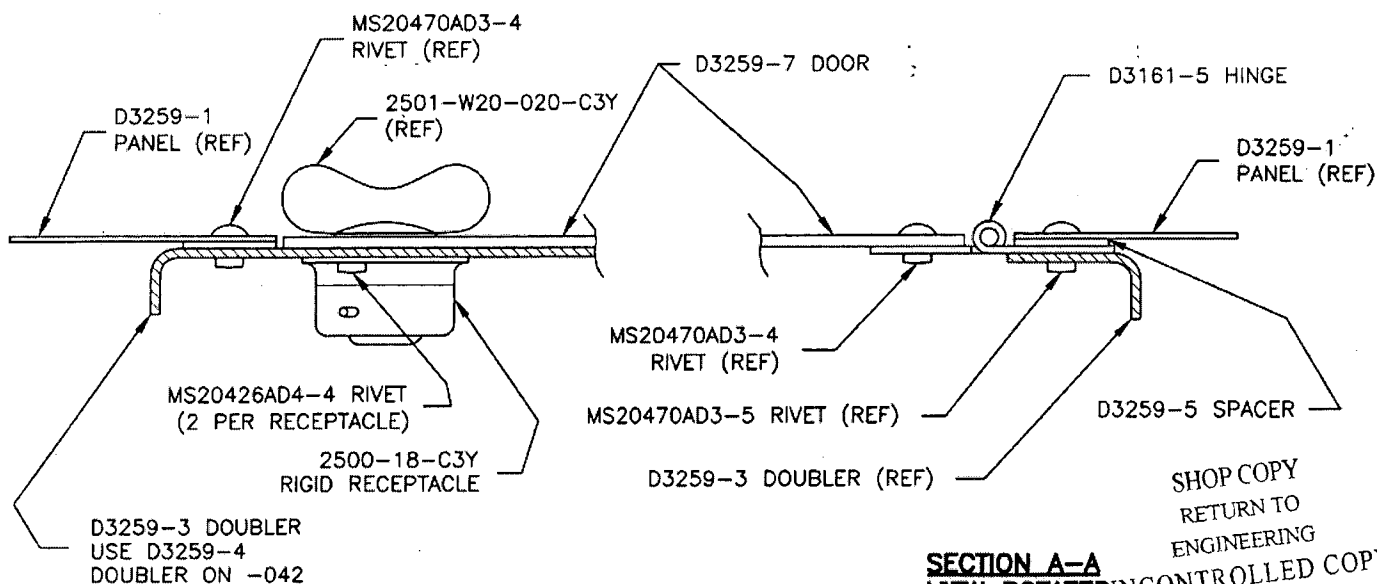
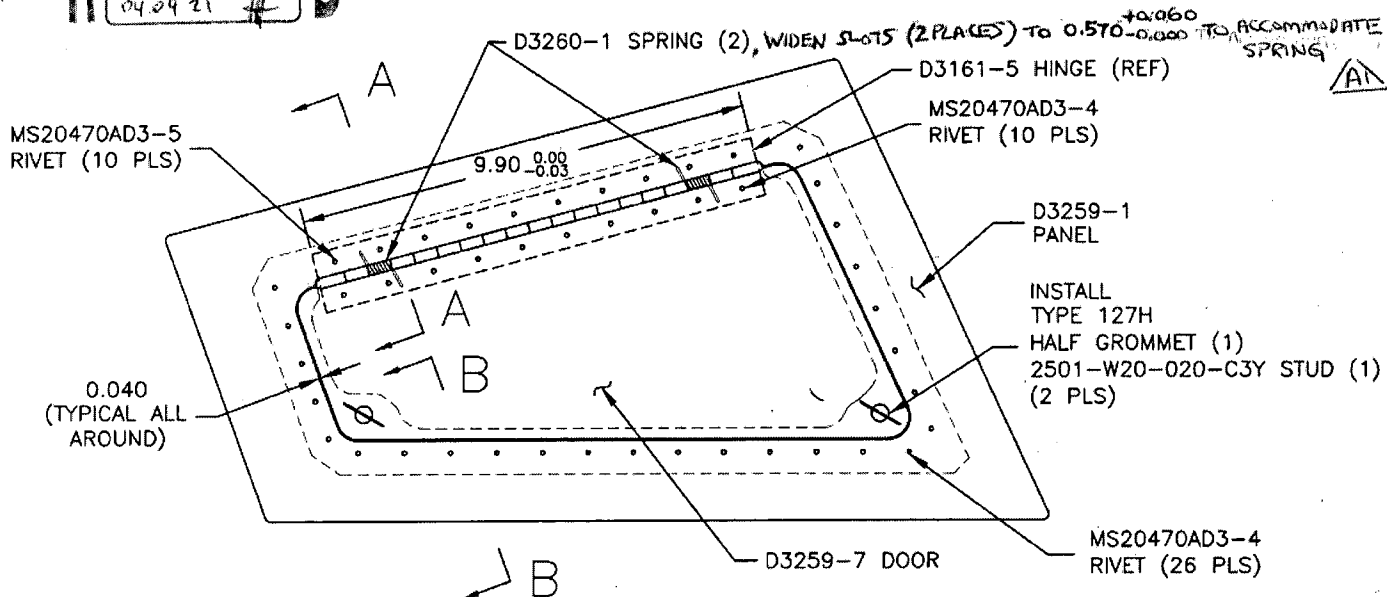
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	RF	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	##	APPROVED	##	DRAWING NO. D3259
				REV. A SHEET 1 OF 6
DATE	04.02.25	TITLE	ACCESS PANEL ASSEMBLY	SCALE 1:4
A	04.02.25	NEW ISSUE		
A1	CP 04.08.11	WIDEN SLOTS TO ALLOW OPERATION OF SPRING		

RELEASED  
04.04.21



**SECTION B-B**  
VIEW ROTATED

**SECTION A-A**  
VIEW ROTATED

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34674

**D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)**  
**D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)**

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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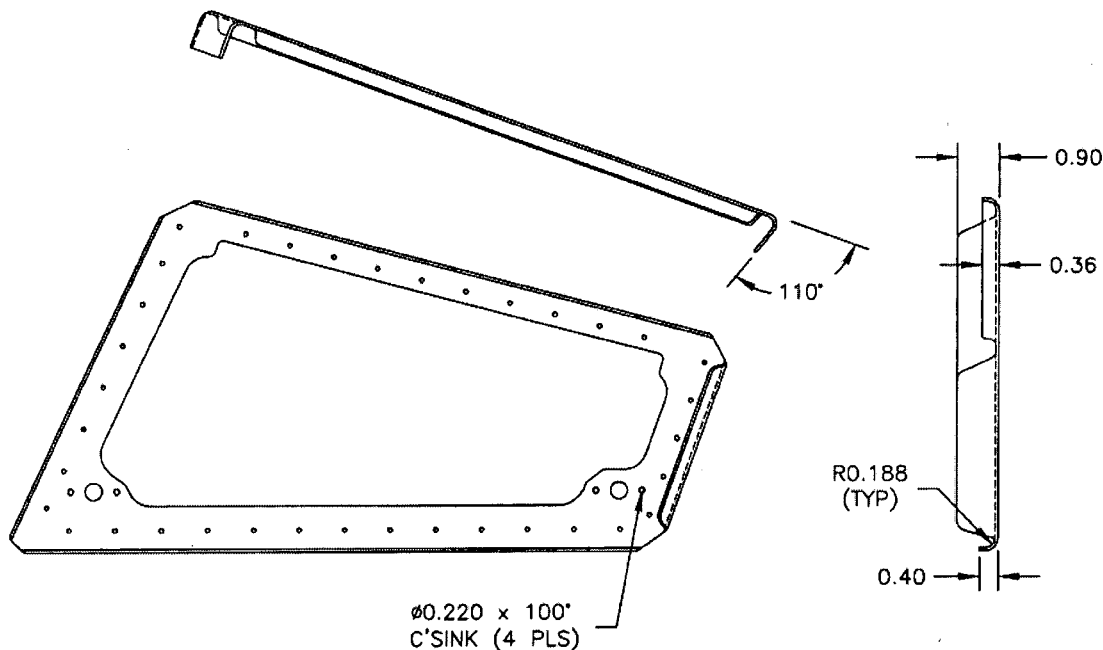
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED  
04.04.14



**D3259-3 DOUBLER BEND DETAIL (SHOWN)**

BEND D3259-4 DOUBLER (OPPOSITE)

**D3259-3/-4 NOTES:**

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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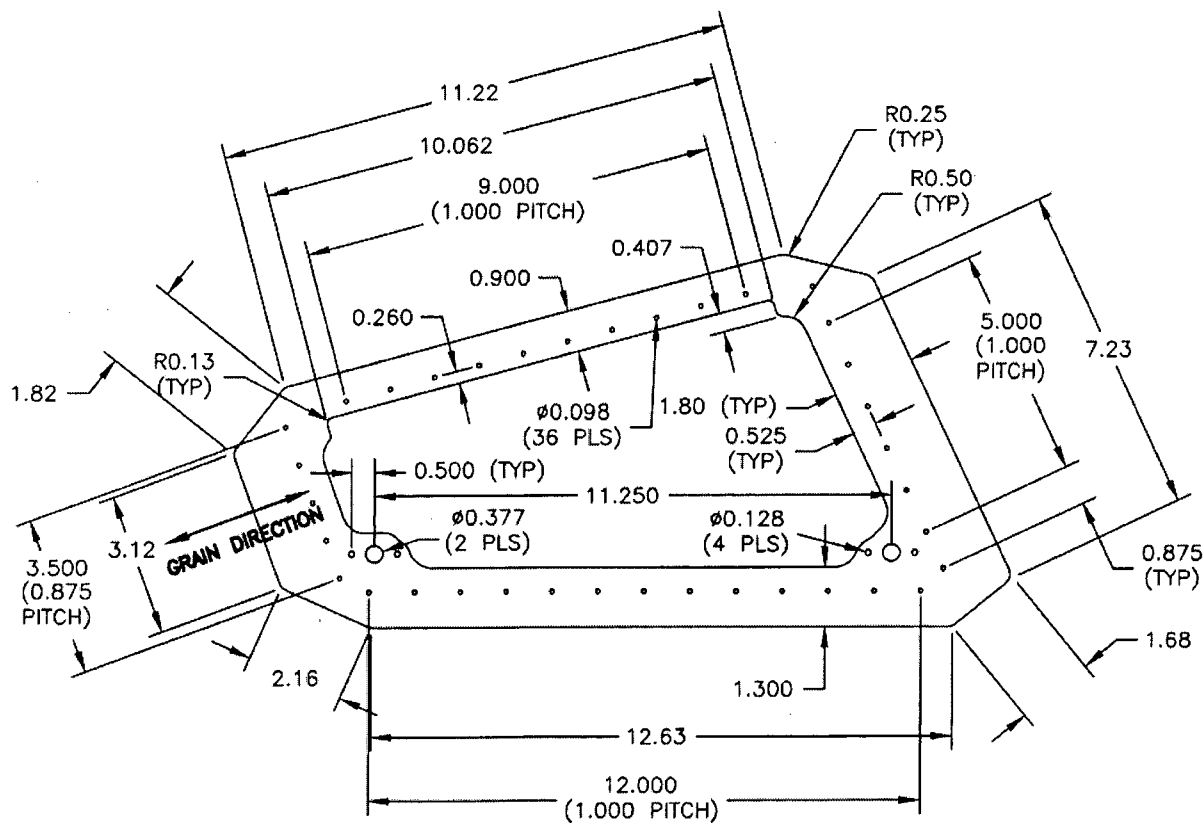
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

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04 04 14 [Signature]



**D3259-3/-4 DOUBLER FLAT PATTERN**  
( $\phi 0.098$  HOLES TO COINCIDE WITH HOLES IN D3259-1)

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NO. 34674

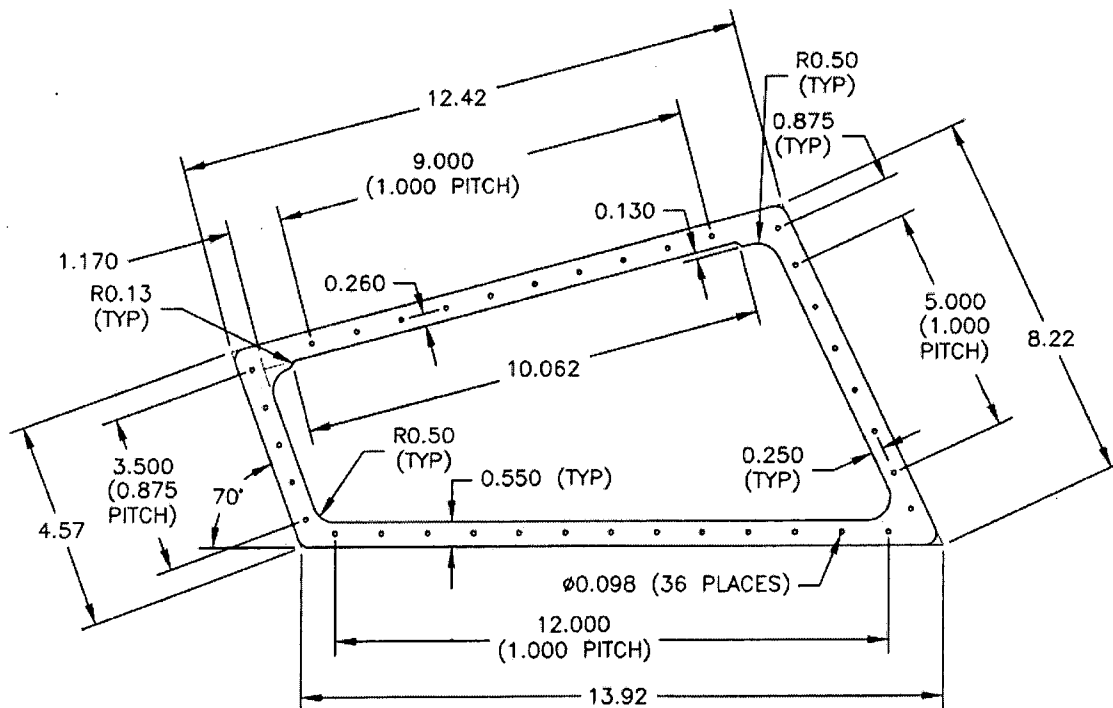
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RELEASED  
04-04-05



**D3259-5 SPACER**

(Ø0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

NOTES:

- 1) MANUFACTURE PER "D3259-A5.DWG"  
2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)  
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
5) ALL DIMENSIONS ARE INCHES  
6) BREAK ALL SHARP EDGES 0.005 TO 0.010
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WORK ORDER

WORK ORDER  
NO. 34674

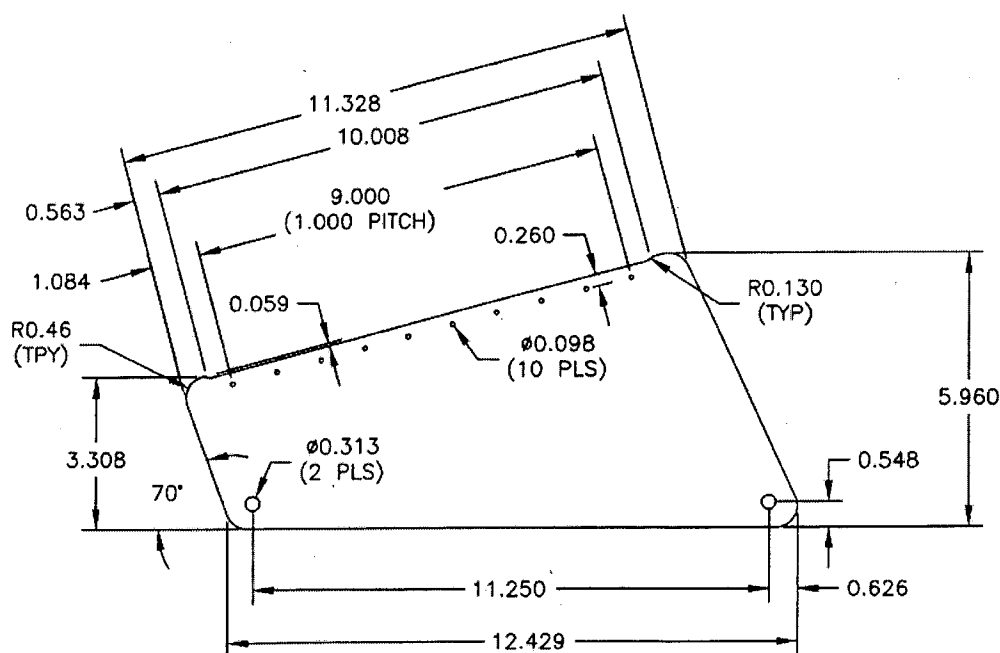
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED  
04-04-14



D3259-7 DOOR

NOTES:

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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